

Work Order ID 68530

Thursday, April 14, 2011 3:57:36 PM



Page 1

Item ID: D3942-3

Accept



Setup Start



Revision ID:

Item Name: Clip

Stop



Start Date: 4/14/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 4/20/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 4-14-11

Tooling:

Date:

Run - Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3942

Rev B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304 - .050

1-Cut as per Dwg D3942-1

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

4311-4-18

(42)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

4311-4-18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

S 11/04/13

0.00

Memo

counted
742

140



Packaging

Packaging

Identify as per dwg & Stock Location: 94

0.00

0.00

Memo

11/4/19 SP (42)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

11/4/19 J

11/4/19

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Picklist Print

Thursday, April 14, 2011 3:57:42 PM

Page 1

Work Order ID: 68530



Parent Item: D3942-3



Parent Item Name: Clip



Start Date: 4/14/2011

Required Date: 4/20/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: Ipp Rev:A UPDATE TO REV B 10-11-24 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA  304/316 .050 Sheet		Purchased	No			100	sf	177.0000	0.015	0.473684	.7		
											AB 11-4-18		

Location

Loc Qty

Loc Code

MAT020

177

111743

1

112178

4

113062

18

116135

48

116604

37

116979

69

111743

48

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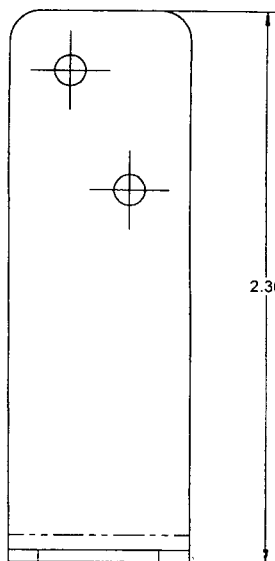
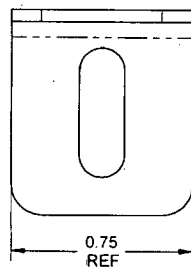
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48530

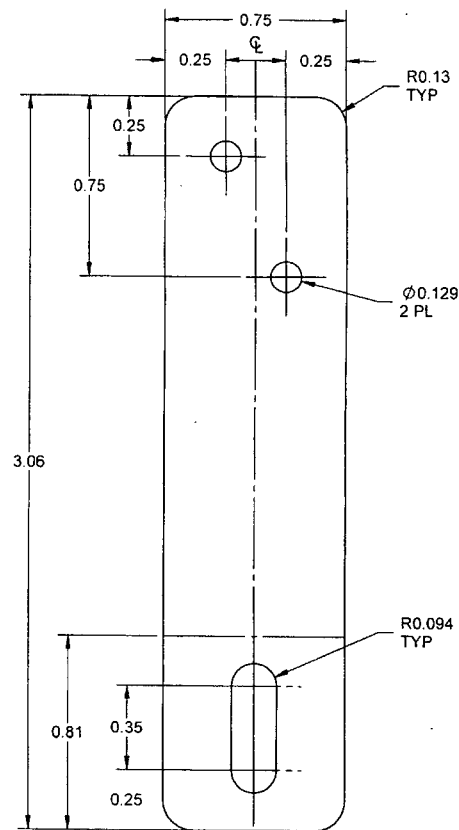
11-04-14



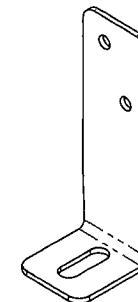
0.050
REF

R0.06

D3942-1 ANGLE
MADE FROM D3942-1F



D3942-1F FLAT PATTERN



RELEASED
2010-11-23

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524
18 GAUGE (0.050 THICK)
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 **B**
- 7) WEIGHT: 0.03 lbs

B	REVISE LENGTH OF -3 PART, ZN C3-2; UPDATE IDENTIFICATION, ZN A7-1, A7-2	HS	10.11.19
A	NEW ISSUE	HS	09.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.19		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3942	REV. B
TITLE BRACKET	SCALE NTS
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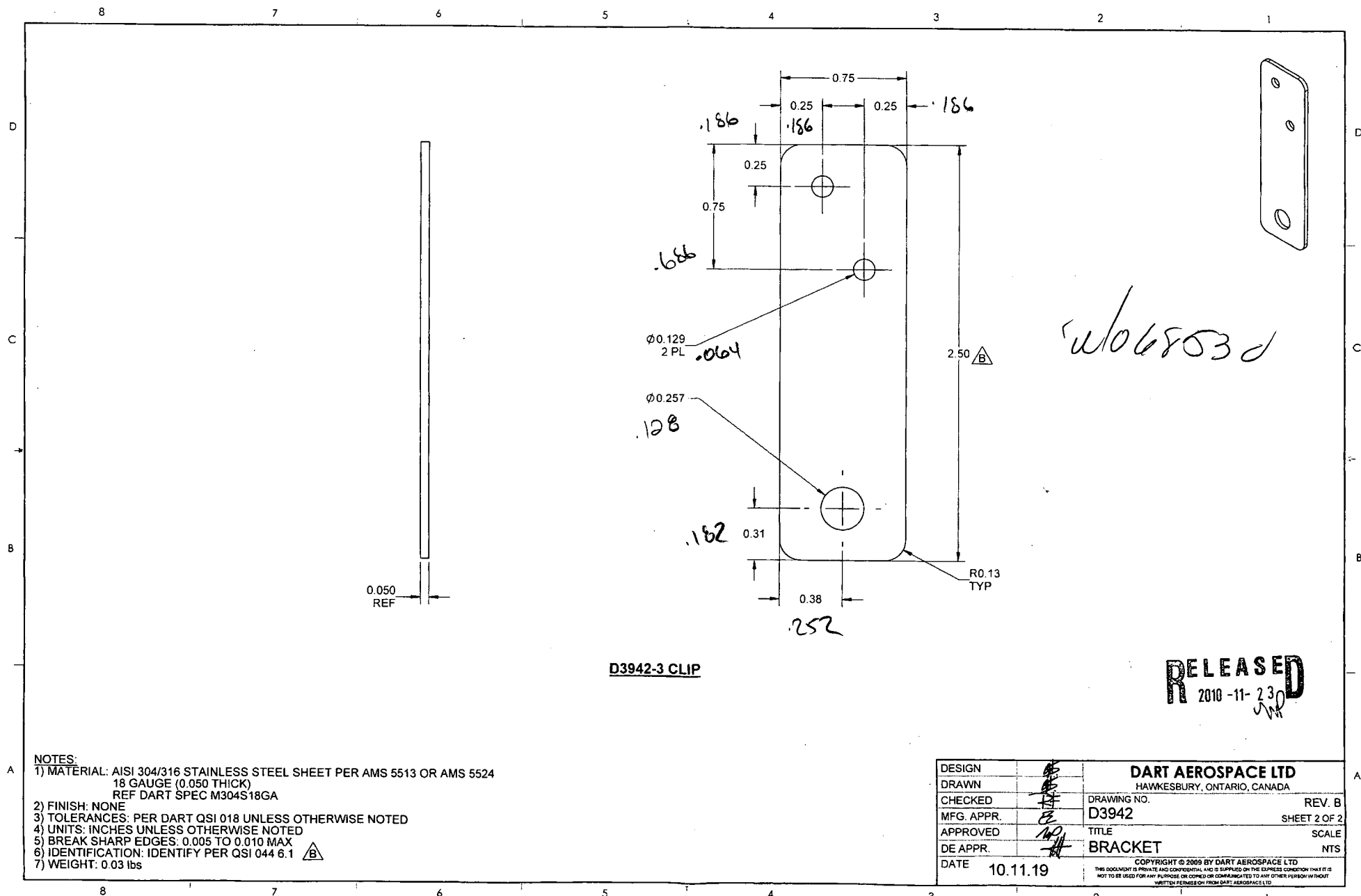
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